

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021747**Date Inspected:** 12-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Sha Zhi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) repair welding of weld joint SEG3020U-587 located on Anchor Plate to Longitudinal Diaphragm at panel point 126 of OBG Segment 14W. ZPMC Welder is identified as 067588. ZPMC Quality Control (QC) is identified as Mr. An Qing Xing. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G-(3F)-FCM-Repair, which is used as per Critical Welding Repair (CWR) B-CWR-2854.

SMAW welding of weld joint SEG3020L-176 located on Floor Beam I-stiffener at panel point 127 bike path side of OBG Segment 14W. ZPMC Welder is identified as 067572. ZPMC Quality Control (QC) is identified as Mr. An Qing Xing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2114-FCM-1.

SMAW welding of weld joint SEG3020L-178 located on Floor Beam I-stiffener at panel point 127 bike path side of OBG Segment 14W. ZPMC Welder is identified as 069896. ZPMC Quality Control (QC) is identified as Mr. An Qing Xing. The welding variables recorded by QC appeared to comply with the Applicable

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

WPS-B-P-2114-FCM-1.

SMAW welding of weld joint SEG3019AW-104 and 105 located on Side Plate to Side Plate at panel point 126 to 127 of OBG Segment 14E. ZPMC Welder is identified as 066163. ZPMC Quality Control (QC) is identified as Mr. Zhang Qing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2212-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3019AW-100 located on Side Plate to Side Plate at panel point 125 to 126 of OBG Segment 14E. ZPMC Welder is identified as 070007. ZPMC Quality Control (QC) is identified as Mr. Zhang Qing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3020R-110, 115, 120 and 125 located on Bottom Plate I-stiffener to Floor Beam at panel point 126 of OBG Segment 14W. ZPMC Welder is identified as 069896. ZPMC Quality Control (QC) is identified as Mr. An Qing Xing. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G-(3F)-FCM-Repair, which is used as per Welding Repair Report (WRR) B-WRR-20375.

SMAW welding of weld joint SEG3020W-078 located on Longitudinal Diaphragm to Floor Beam at panel point 125 to 125.6 of OBG Segment 14W. ZPMC Welder is identified as 067942. ZPMC Quality Control (QC) is identified as Mr. An Qing Xing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

Flux Core Arc Welding (FCAW) welding of weld joint SEG3020K-305, 306, 309 and 310 located on Bottom Plate Stiffener to Floor Beam of OBG Segment 14W. ZPMC Welder is identified as 204730. ZPMC Quality Control (QC) is identified as Mr. An Qing Xing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

FCAW welding of weld joint SEG3020L-107, 113, 119 and 125 located on Bottom Plate Stiffener to Floor Beam of OBG Segment 14W. ZPMC Welder is identified as 066239. ZPMC Quality Control (QC) is identified as Mr. An Qing Xing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

This QA inspector observed ABF personnel performed Magnetic Particle Testing (MT) after back gouging welding on Floor Beam to Side Plate at panel point 128.7 cross beam side. The weld number is identified as SEG3020C-050. See the attached pictures.

SMAW welding of weld joint SEG3013K-154 and 155 located on Side Plate I-stiffener to Stiffener of OBG Segment 13AW. ZPMC Welder is identified as 067603. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-B-U2-FCM-1.

SMAW welding of weld joint SEG3013-004 located on Deck Panel to Deck panel of OBG Segment 13AW. ZPMC Welder is identified as 069683. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3013-006 located on Deck Panel to Deck panel of OBG Segment 13AW. ZPMC Welder is identified as 067609. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3013F-111 located on Side Plate I-stiffener to Side Plate I-Stiffener of OBG Segment 13AW. ZPMC Welder is identified as 066459. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3013M-031 and 032 located on K-Plate to Deck Plate at panel point 118.35 to 119-1500 of OBG Segment 13AW. ZPMC Welder is identified as 066361. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2114-FCM-1.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Vibin

Quality Assurance Inspector

Reviewed By: Patel,Hiranch

QA Reviewer